

Work Order ID 51571

August 26, 2009 12:38:56 PM

SHIP TODAY



Item ID: D3684-041
Revision ID: C
Item Name: TRIPOD MOUNT ASSEMBLY

Accept



Setup Start



Stop



Start Date: 8/26/09 Start Qty: 1.00
Required Date: 8/26/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3684	Rev C

100	Pick Kit	0.00
-----	----------	------



Packaging	Memo	0.00
-----------	------	------

Packaging

Suppl 826

110	QC4- 100% Inspect kits for completeness	0.00
-----	---	------



QC	<i>5 In ASS'y see attached</i> Memo e-mail.	0.00
----	--	------

Quality Control

120	Identify as per dwg & Stock Location: _____	0.00
-----	---	------



Packaging	Memo	0.00
-----------	------	------

Packaging

86 02608/26

9/8/26 @ Sy

6908.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3684-041

Accept

Revision ID: C

Item Name: TRIPOD MOUNT ASSEMBLY

Start Date: 8/26/09 Start Qty: 1.00

Required Date: 8/26/09 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/08/26

h 09.08.26

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 26, 2009 12:38:56 PM

Page 1 / 2

Work Order ID: 51571

Parent Item: D3684-041RevC

Parent Item Name: TRIPOD MOUNT ASSEMBLY



Comments:

Start Date: 8/26/09

Required Date: 8/26/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	481.0000	2.0000			
												
Bolts												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	481	
106993	7	
110155	2	
110552	3	
110584	29	
111916	20	
112314	420	

D3684-043RevC

Manufactured No

110 Each 3.0000 1.0000



MOUNT ASSEMBLY

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
51144	3	

D3684-045RevC

Manufactured No

110 Each 4.0000 1.0000



LEG ASSEMBLY

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST139A	4	
51152	4	

SB 09/08/26

SB

SB 09/08/26

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Picklist Print

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Page 2

Work Order ID: 51571

Parent Item: D3684-041RevC

Parent Item Name: TRIPOD MOUNT ASSEMBLY

Start Date: 8/26/09

Required Date: 8/26/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3692-1RevB		Manufactured	No			110	Each	382.0000	4.0000			



SPACER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 59

44827 8

45672 14

50325 37

Main Warehouse

ST127 323

50736 323

MS21043-3

Purchased

No

110

Each

5,382.000

2.0000



Nut

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 80

103691 80

Main Warehouse

ST 5302

111819 88

112243 238

112314 4976

24 88

2 SA 09/08/20

August 26, 2009 12:38:56 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

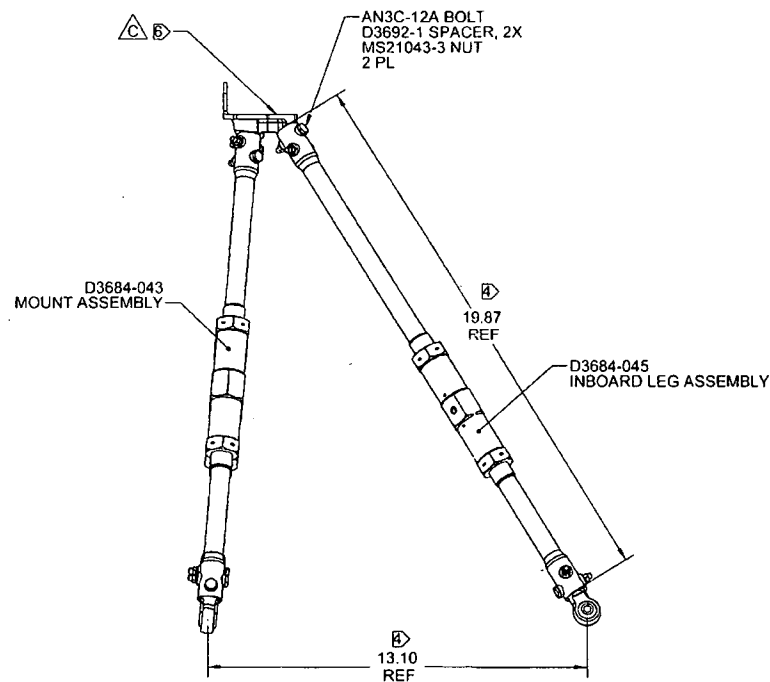
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NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3684-041	TRIPOD MOUNT ASSEMBLY
2	1	D3684-043	MOUNT ASSEMBLY
3	1	D3684-045	INBOARD LEG ASSEMBLY
4	4	D3692-1	SPACER
5	2	AN3C-12A	BOLT
6	2	MS21043-3	NUT

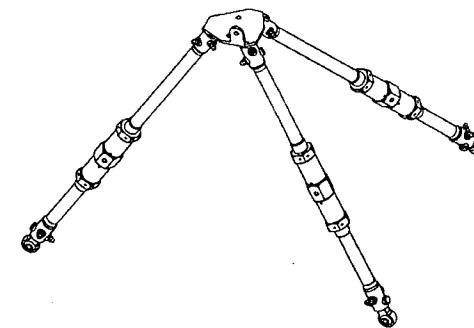


D3684-041 TRIPOD MOUNT ASSY 

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3/-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 9.9 lbs

- 6) ASSEMBLE D3684-045 WITH D3684-043 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT
- 7) ASSEMBLY SHOWN FOR REF ONLY, -041 IS PACKAGED UNASSEMBLED



RELEASED
08/12/15

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, D6-1, A8-2, D4-2, A8-3, B4-3, A8-4, B4-4, A8-5, B5-5); ASSEMBLY NOW SHOWN FOR REF ONLY (ZN A8-1, A4-1)	RF	08.12.15
B	19.52 WAS 19.50 (ZN C6-2); 9.20 WAS 9.70 (ZN C6-2); 20.74 WAS 21.24 (ZN C6-4); 6.95 WAS 6.88 (ZN D5-5); MODIFIED PER PROTOTYPE INSTALLATION; REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3684** REV. C
SHEET 1 OF 5
TITLE **TRIPOD MOUNT ASSY** SCALE NTS

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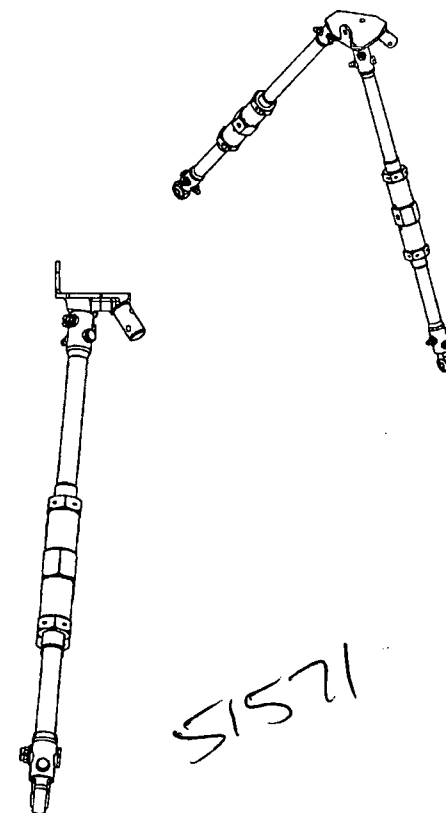
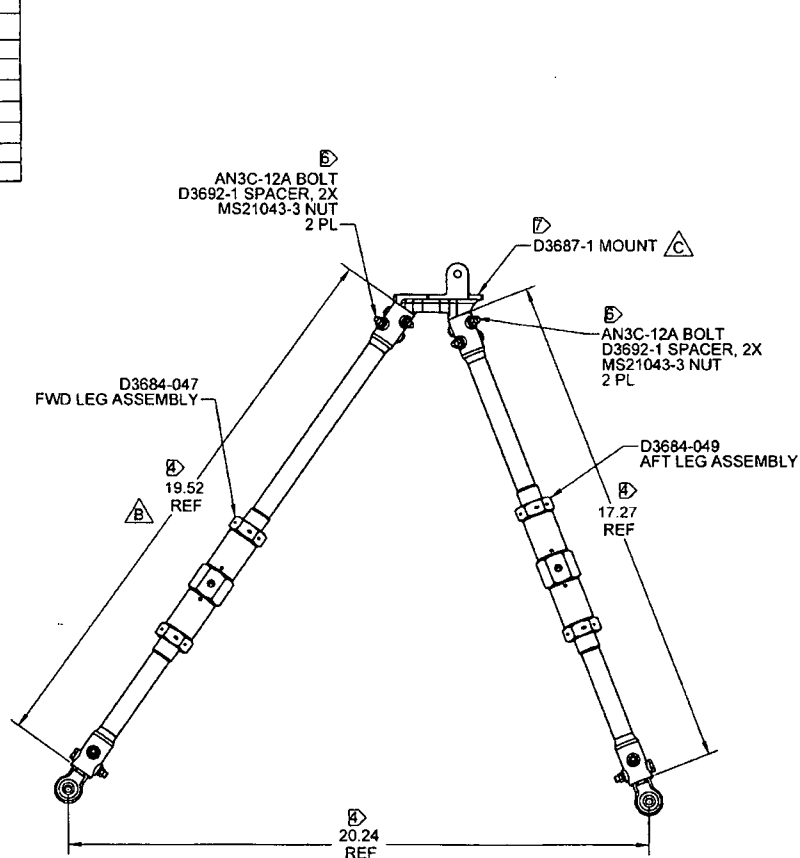
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D3684-043	MOUNT ASSEMBLY
2	1	D3687-1	MOUNT
3	1	D3684-047	FWD LEG ASSY
4	1	D3684-049	AFT LEG ASSY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



D3684-043 MOUNT ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-043 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT



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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	GP	D3684	SHEET 2 OF 5
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	TRIPOD MOUNT ASSY	NTS
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RELEASED
09/01/12

W/O:		WORK ORDER CHANGES					
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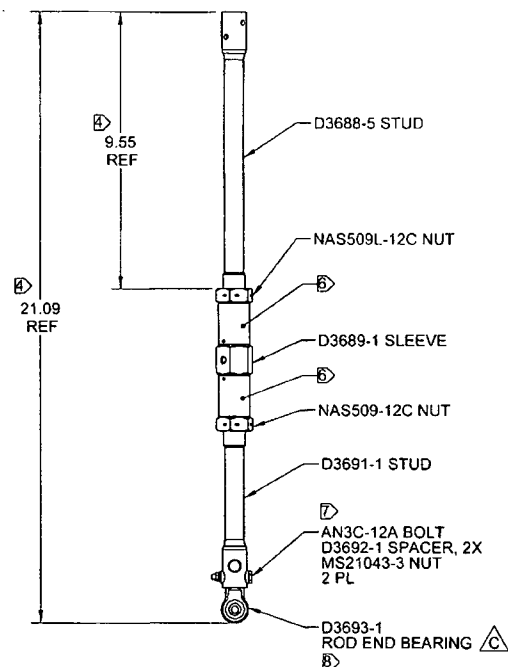
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NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D3684-045	INBOARD LEG ASSEMBLY
2	1	D3688-5	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT






D3684-045 INBOARD LEG ASSEMBLY

51571

RELEASED
09/01/12 MFB

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3684-045 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSION SHOWN IS WHEN D3688-5 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.1 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.		D3684	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TRIPOD MOUNT ASSY	NTS
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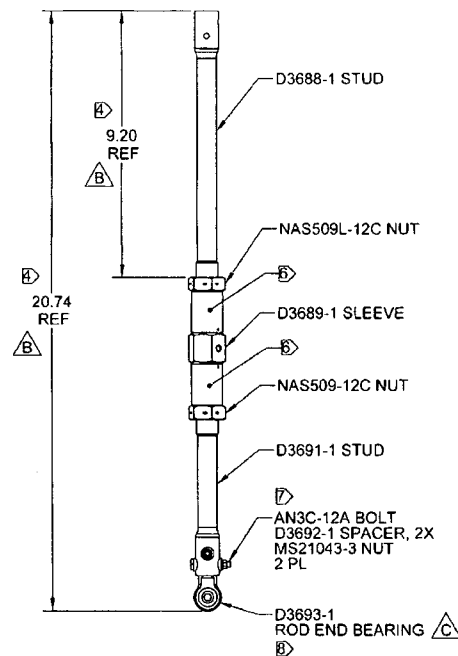
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NOTE: Date & initial all entries

ITEM	QTY -047	PART NUMBER	DESCRIPTION
1	X	D3684-047	FWD LEG ASSEMBLY
2	1	D3688-1	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-047 FWD LEG ASSEMBLY



51571

RELEASED
09/01/12

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.10 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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CHECKED		DRAWING NO.	REV. C
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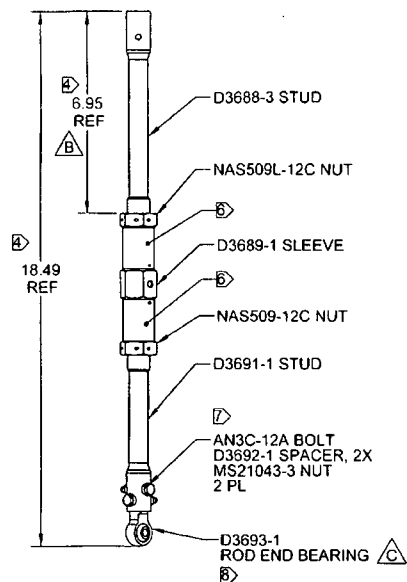
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NOTE: Date & initial all entries





ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.88 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

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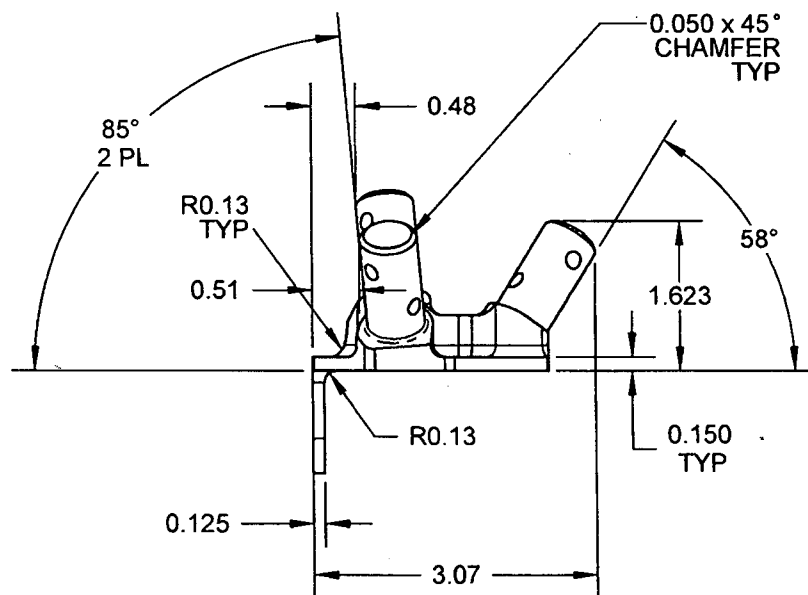
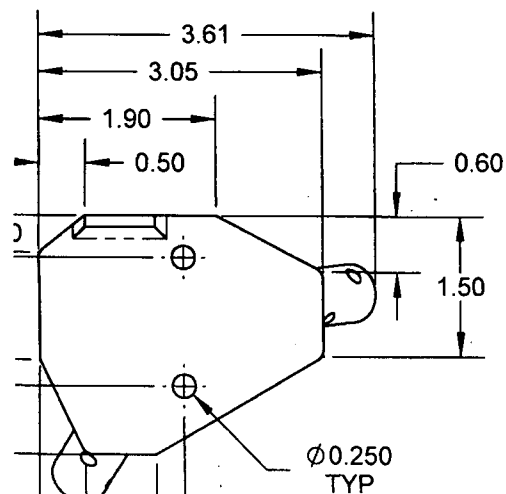
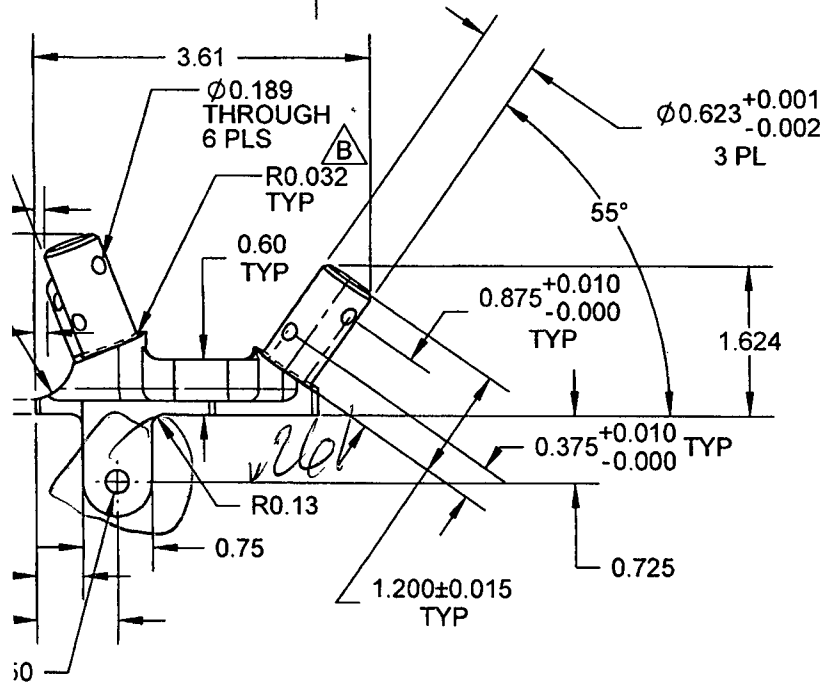
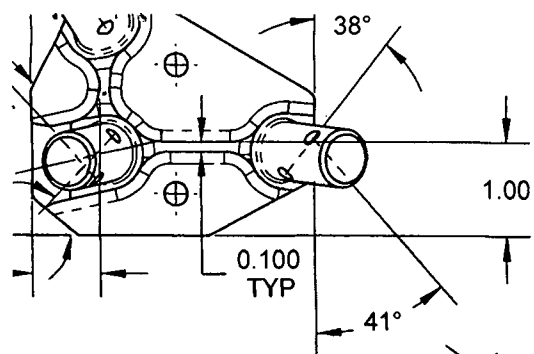
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NOTE: Date & initial all entries



D3687-1 MOUNT



NOTES:

- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

B	CHANGE TO 17-4PH H-900 (ZN A6-1 & R0.015 (ZN C7-1 & C7-2); REFORMAT DWG STANDARDS		
A	NEW ISSUE		
REV.	DESCRIPTION		
DESIGN	RF	D/ H/ DRAWING NC	
DRAWN	RF		
CHECKED	DP		

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

L Lacelle

From: Sian Willems [swillems@dartaero.com]
Sent: August 26, 2009 2:05 PM
To: peggy@darths.com
Cc: 'Shirley Hay'; 'Suzanne Bedford'; asauve@dartaero.com; 'Jason Murdoch'; 'L Lacelle'; 'Mike Petsche'
Subject: NCR09-084 WNC Overseas Aircraft Services
Attachments: NCR09-084 Overseas Aircraft Services.xls



NCR09-084
Overseas Aircraft Se.

Hi Peggy,

Please see attached no charge. Customer received engine mount and found that one leg of the tri pod (which comes unassembled to reduce shipping costs) could not be assembled.

To ship to day.

We're testing the no charge tripod prior to sending. We'll issue an RMA. I will contact customer directly with RMA details.

Please call if you have questions.

Sian Willems

Marketing

T - 1.613.632.5200

F - 1.613.632.1185

C - 1.613.676.0577

swillems@dartaero.com

DART Aerospace Ltd.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Request For Quote ☒
 Sale Order ☒
 Purchase Order ☐

Date of Creation
 26-Aug-2009

RFQ/S.O./P.O. Number

Customer Billing Details		
Sales Rep:		
Customer Name: Overseas Aircraft Support		
Contact Name: Ralph Schreiber		
Customer P.O.: Warranty NCR09-084 PO12540		
Customer Code:		
Customer Billing Details Shaded areas must be filled in	Address	
	City / State	
	Postal Code	
	Country	
Customer Phone:		
Customer Fax:		
Customer Cell:		
Customer Website:		
Contact e-mail:		
Return Authorization		
Non Conformance 09-084		

Shipping Instructions		
Company Name:		Overseas Aircraft Support
Contact Name:		Ralph Schreiber
Contact Phone:		1-928-368-6965
Special Instructions:		
Customer Shipping Details Shaded areas must be filled in	Address	727-B Woodland Road
	City / State	Lakeside, AZ
	Postal Code	85929
	Country	USA
Method of Payment:		N/A
Card Holder Name:		N/A
Credit Card #:		N/A
ABN / IRS / GST #:		
Freight Forwarder:		Federal Express
Account #:		1517-9324-0 DAS
Type of Service:		Int'l Priority
Ppd/Chg USD <input type="checkbox"/>	Collect <input type="checkbox"/>	Prepaid USD <input checked="" type="checkbox"/>
Customs Included USD <input type="checkbox"/>		N/A \$

Product Order List													
Item	Qty	Product Number	Product Availability	Product Description	Batch Number	Supplier	Unit Retail Price	Customer Discount	Discount Per Unit	Customer Invoice Amount	DHS Commission	DHS Commission	DHS Invoice Amount
1	1	D3684-041	QC	Tripod Mount Ass'y		DAS	\$ -	100%	\$ -	\$ -	0%	\$ -	\$ -
2							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
3							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
4							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
5							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
6							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
7							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
8							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
9							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
10							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
11							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
12							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
13							\$ -	0%	\$ -	\$ -	0%	\$ -	\$ -
Sub Total										\$ -		\$ -	\$ -
Freight										\$ -		\$ -	\$ -
Total										\$ -		\$ -	\$ -

All figures are in US dollars

DHS INTERNAL CORRESPONDENCE

NCR09-084. Customer received D205-770-011 B44427, DAS SO100302, DHS 8011374, customer PO 12540. Tripod leg won't assemble correctly. Parts to be supplied by QC (pre-tested for assembly before sending). Ship Aug. 26.

COMMENTS FOR PURCHASE ORDER

NCR09-084. Customer received D205-770-011 B44427, DAS SO100302, DHS 8011374, customer PO 12540. Tripod leg won't assemble correctly. Parts to be supplied by QC (pre-tested for assembly before sending). Ship Aug. 26. **ON PACKING SLIP: NCR09-084. Replacement Tripod D3684-041 for D205-770-011 B44427, customer PO 12540.**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

502741

L Lacelle

From: Jason Murdoch [jmurdoch@dartaero.com]
Sent: August 26, 2009 12:21 PM
To: 'Mike Petsche'; 'L Lacelle'; 'Sian Willems'
Cc: 'Bill Beckett'
Subject: RE: TRipod

Hi L,
Have you been asked to create a w/o to assemble the unit so we can ship? (Kind of like the aft seat & harness deal) If not I think we should get one. Thank you.

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: August 26, 2009 12:02 PM
To: 'L Lacelle'; 'Jason Murdoch'; 'Sian Willems'
Cc: 'Bill Beckett'
Subject: RE: TRipod
Importance: High

Oh and please be sure that the hole in the tab of the machined part had been opened up to .261"

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: Wednesday, August 26, 2009 11:59 AM
To: 'L Lacelle'; 'Jason Murdoch'; 'Sian Willems'
Cc: 'Bill Beckett'
Subject: TRipod
Importance: High

All,

We need to send (1) FULLY ASSEMBLED tripod kit D3684-041 to Ralph at Overseas.

He will also need an RMA to return the kit he has (that will not go together).

Obviously....it's gotta go overnight.....

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

8/26/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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